

SPC 15

DART AEROSPACE LTD	Work Order: 24299 A
Description: Handle + Lock down	Part Number: D3451-041, 043, 045, 047
Dwg: D3451 Rev A	Qty: 17
	Page of

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	WA	cut material M6061T6 B0.125 x 1.000 per drawing D3451 Rev A	FF	05.09.09	34
3		2 each of D3451-1	FF	05.09.09	34
		D3451-3	FF	05.09.09	34
		D3451-5	FF	05.09.09	34
		D3451-7	FF	05.09.09	34
3	WA	cut 4x B67-43001-103 M18188 per drawing D3451 Rev A	FF	05.09.09	68
4	WA	weld per drawing D3451 Rev A & deburr	CPL	05.09.26	20
5	QC	Inspect Level 5		05.09.27	20
6	FP	Acid Etch + Alodine	M	05.09.27	20
7	FP	Mask parts per drawing	M	05.09.27	20
8A	FP	powder coat green sandtex	M	05.09.27	20
9	QA	pick GP-211 x2 - cut as shown and assemble N17844	SB	05.09.27	20
10	Stores	Identify & stock (GTM SEARCH)	A	05.09.27	20
11	AC	Cost / part			
12	DC	Inspect Level 21			
8b	QC3	Inspect powder coat		05.09.27	20

Rev	Date	Change	Revised By	Approved

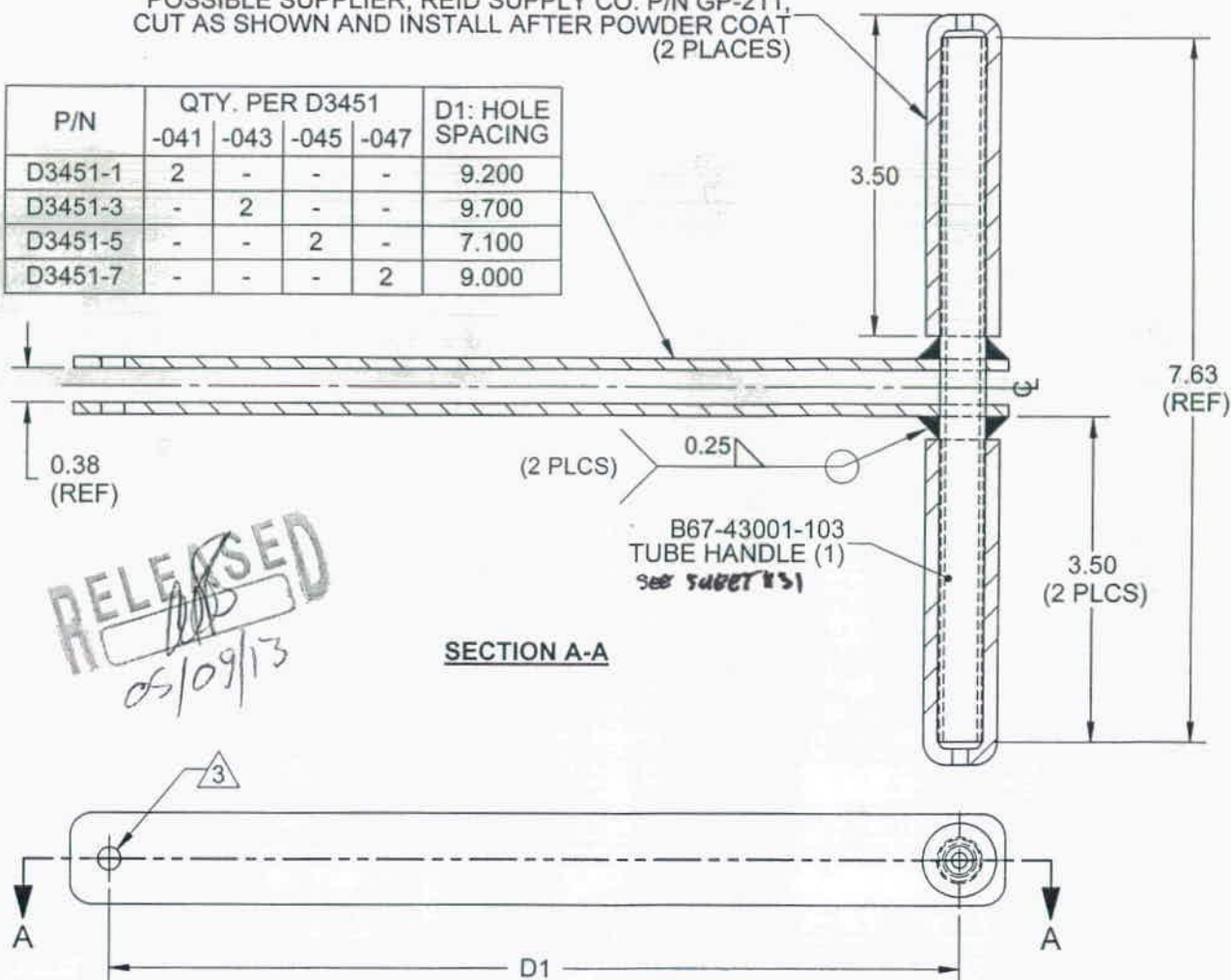




DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 1 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y	SCALE 1:2
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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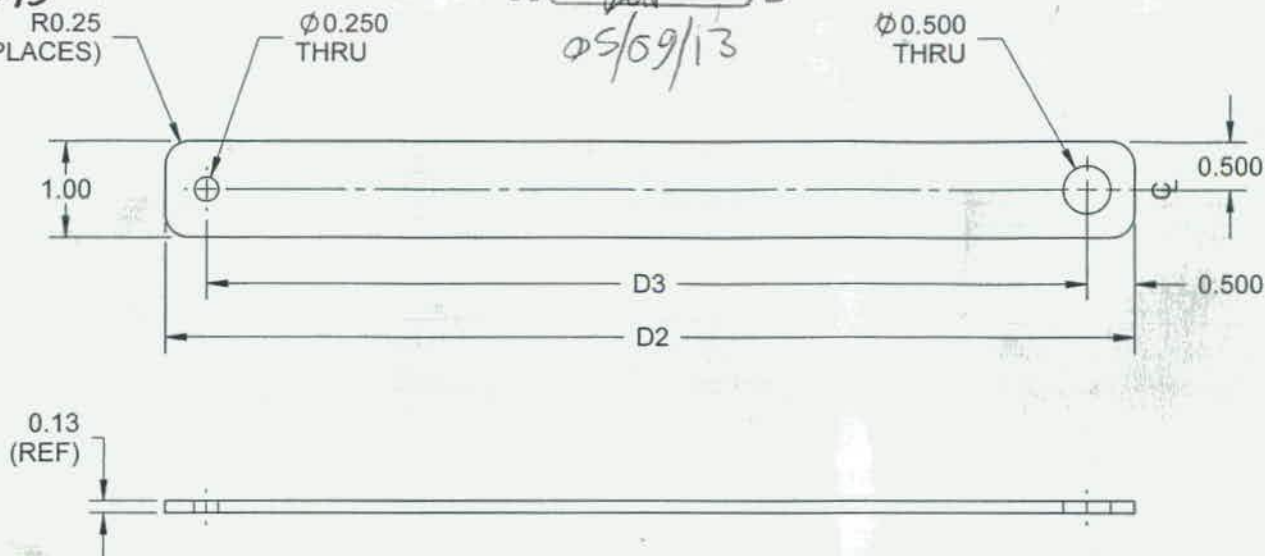
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2	

M17037 M18147
M17918 M16954
M16807
M17695

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05/09/13



P/N	D2: CUT LENGHT	D3: HOLE SPACING
D3451-1	10.25	9.200 ✓
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303

D3451-5 SUPERSEDES PREMIER P/N B67-43001-301

D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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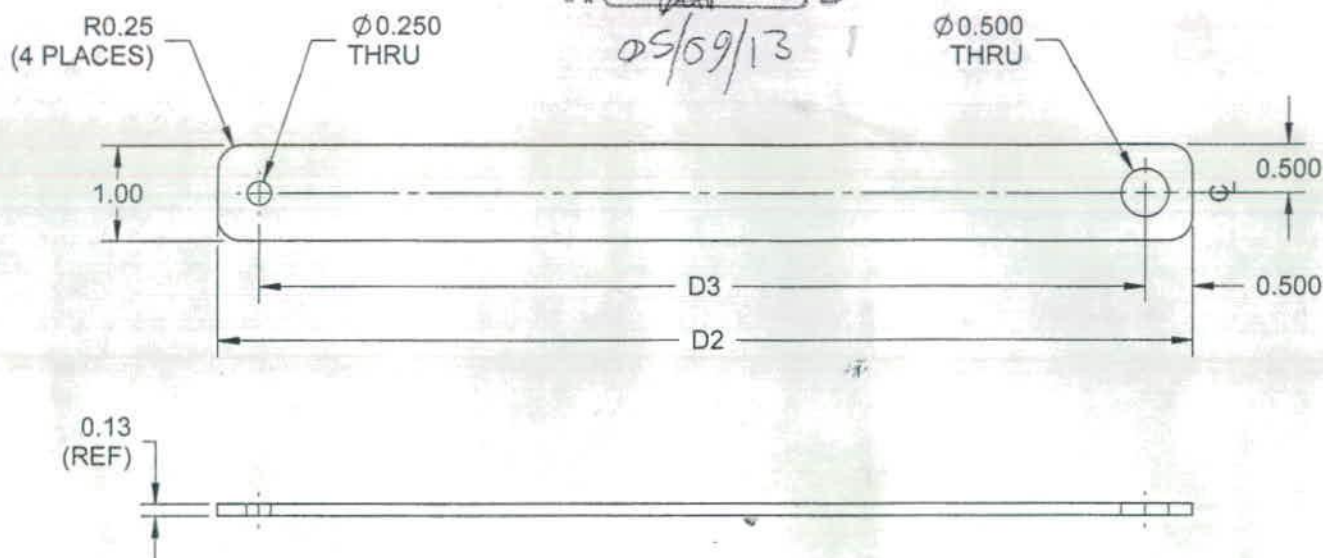
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DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y	SCALE 1:2

RELEASED
[Signature]

05/09/13



P/N	D2: CUT LENGTH	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
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D3451-1/-3/-5/-7 TUBE HANDLE ARMS

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D3451-5 SUPERSEDES PREMIER P/N B67-43001-301

D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
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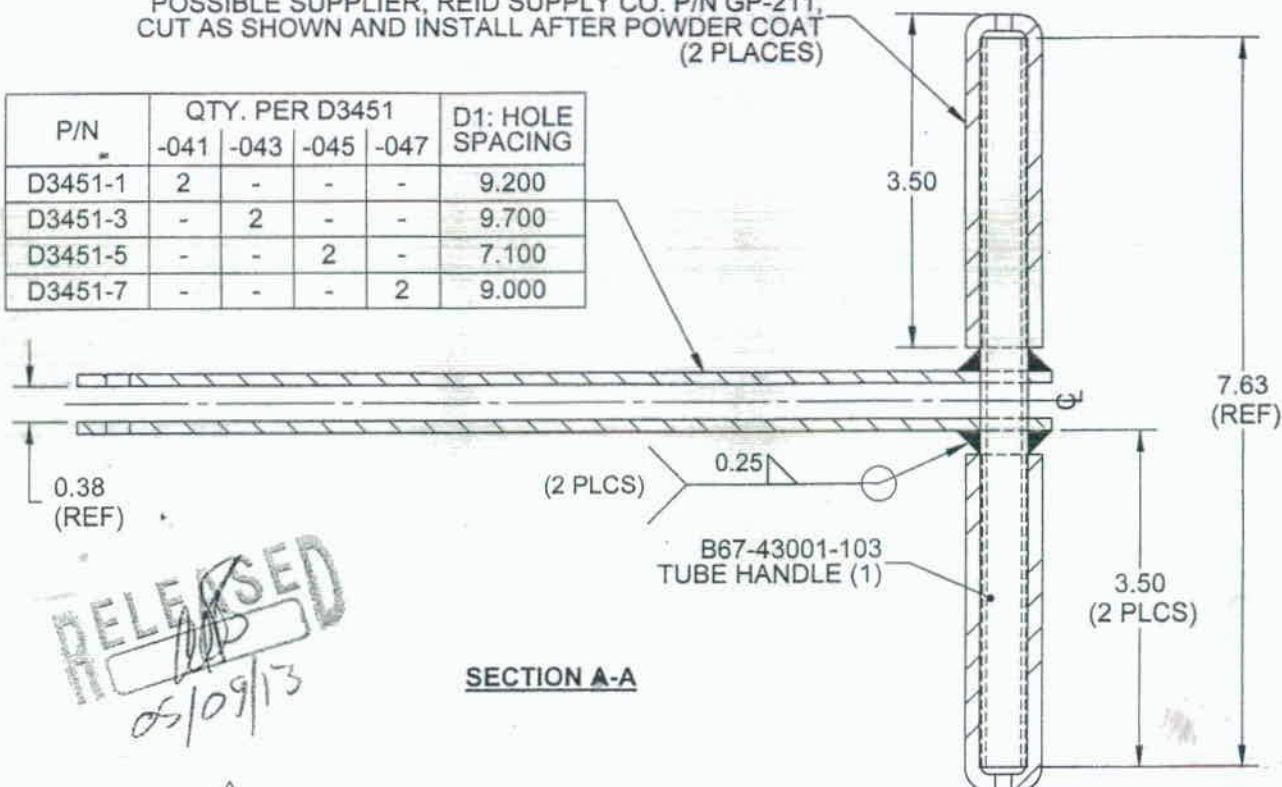
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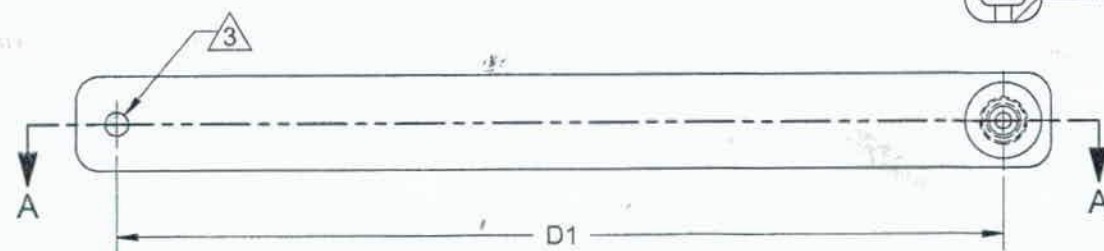
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SECTION A-A



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

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